Work Order ID 56263 Wednesday, February 17, 2010 11:05:02 AM												Page
Item ID: D206-642-341 Revision ID:				Accept					Setup St	1 10 2 1140		
	2/18/2010					Cust Item ID: Customer:						
Approvals:	Process Pla			Date:			ate:		1		art	
Sequence ID/ Work Center II		Operation Description			Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Kev	vision Nbr										
100		DOCUMEN	NT CONTRO	L	0.00				NA	#		entroper per rout rout el
DC Document Control		•	Memo Photocopy b	luefile and create lat	0.00 Dels per PPP D206-642-341	<i>Мо°о</i> 5°3>> Снечоў				-0-		
		Skidtubes			0.00	·						4
Skidtubes Skidtubes			Dwg D2650	□3-Weld Fwd Cap a	0.00 emove ridge on inside of Fwd as per Dwg D2650. Use alumi luminum Rod <u>MII2507</u> □5-Cut af MII320	l edge of tubeas per 1 num rod. Grind 	+2 BF 10	DP	10 - Z	- 18		pto

120

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

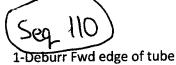
110/2/23

BE 10-2-18

w/o: 52	Ja63	WORK ORDER CHANGES					i ;
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/97/03	4	Fix or \$ ADD Routing numbers AREA TO See your					Colories
	No.						

Part No: 0206-642-341 PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
D. 17-		Description of NC	Corrective Action Section B			Verification	Anneoval	Аппион			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approva QC inspecto			
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		./									
			.,								



A/R

1-Deburr Fwd edge of tube
2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650 MIO/U/23
3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.
A/R Aluminum Rod $m1 r2507/m113207$ BE $19/02/a2$
4-Grind weld flush to cap on top surface only.
5-Cut aft end to length as per dwg D2650 $h_{12}/2/21$
6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312"
6-Drill pilot holes using drill Jig DT8168A (A,& B) and DT8025. Open to Ø0.312" 7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297". 8-Open Aft Cap Hole using #6 Drill Bit
8-Open Aft Cap Hole using #6 Drill Bit
9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail
10-Remove inner indexing ridge on aft end of skidtubeas per Dwg D2650 ψ (2002)
11-Deburr and Blow out all chips form inside the tube $\psi (\alpha 2/2)$
1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)
2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)
3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.
4-Bond D2654-5 web in place as per QSI 015Ensure holes line upAllow 12 Hrs. cure time before cutting
Start Date: Vhlv3 Time: 11:00
Finish Date: Walzy Time: 8:45 mg
A/R Sikaflex-291 MIZ429
Sikaflex expiry date: 10/3/37 -Deburr Fwd edge of tube
2-Remove ridge on inside of Fwd edge of tubeas per Dwg D2650
3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Aluminum Rod 1112507 BE 10/2/25

Work Order ID 56263



Page 2

Wednesday, February 17, 2010 11:05:02 AM

Item .	IV:	

D206-642-341

Accept



Setup Start

Stop

Stop

Reject



Revision ID:

Item Name:

Replacement Skidtube

Start Date: Required Date: 3/4/2010

Start Qty: 1.00 2/18/2010

Req'd Qty: 1.00



Cust Item ID:

Customer:

Draw

Number

Reference:

An	nrove	le.
Αp	prova	115:

3.5

Process Plan:

Operation .

Description

Date: _____

Tooling:

Set Up/

Run Hours

Date:

Date:

Draw

Rev.

Run Start

Reject

Qty



Insp.

Sequence ID/ Work Center ID

130



Skidtubes Skidtubes

Skidtubes

Memo

0.00

0.00

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)□3-Deburr. Blow out chips. Grind alodine off

around crossbolt spacer. □4-Bond D26

Date: _____ SPC (Y/N):

110/2/23

Plan

Code

Number Stamp

140

QC

Quality Control

Memo #

0.00

Accept

Qty

150

Skidtubes

Skidtubes

Skidtubes

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. \(\sum A/RAluminum Rod \(\gamma \) / 1/250 \(\frac{2}{3} \) = Grind welds flush as per Dwg D2650. Masking Tape access to

Dart /	Aerospace	Ltd
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3.5. 4. 6960112 19

W/O:	rqs.	WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
						F*				
		•								

Part No: D206-642-341 PAR #: NA. Fault Category: Skidhebe NCR: Yes No DQA: A Date: 10.04.27

Resolution: Resolutio

NCR: 50	6263	We	WORK ORDER NON-CONFORMANCE (NCR)					
DATE STEP		Description of NC	Corrective Action Section B			Verification	Annessal	Ammunual
		Section A	Initial Chief Eng			Section C	Approval Chief Eng	Approval QC inspector
loleros	少(2)	Durin countre borein employee Dole I the pilot in the host Boode hade un Rus section. After Replace and countreborein the second since be notreed that	Sun	Drill out 4-bolt spaces. 3, 5, 8, 9, 10, 11, 12, 19th from	102-25	Saylot	psin	8 10/02/25
		The holes were ovalized. Occupants rease all holes and found off 88 that are once 0.385"	Lasiun	- Replace DZ649 QH x 8 B 55000 - Re weld as per Q57004	BE 12-2-25	(अंक्री)	pssion	(a)(a) 25
			Jessun	- egrino sotel voldo Flust	BE-25 102-25 10-25	Spiles Single	Suy	Solops

1 Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R , Aluminum Rod M112507 RE 10/02/24
2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube & 1402/2
2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube $\mathcal{B} \in \mathcal{A} \setminus $
Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.
A STATE OF THE STA
1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.
A/R Sikaflex-291
Sikaflex expiry date:
2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive
3-Install MS27039-4-06 Screw as per DEO 9153
4-Inspect for foreign object per QSI 024
5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive
A/R Sikaflex-291
Sikaflex expiry date:
6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4

Batch:

					*						
Work Order ID 56263 Wednesday, February 17, 2010 11:05:02 AM											Page 3
Item ID: Revision ID: Item Name:	D206-642-3			Accept				s s	etup Star Stop	1 10011101 01	
Start Date: Required Date: Reference:	2/18/2010 Start Qty: 1.00		18614 161 186 18714 161 180	Cust Item ID: Customer:					!		
Approvals:	Process Pla	an:	Date:	Tooling:	Da	 nte:	_	R	un Star	't	
	QC:		Date:	SPC (Y/N):	Da	ıte:			Stoj	P	
Sequence ID/ Work Center II)	Operation Description HandFinishing		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
HandFinish Hand Finishing		Memo	:0-041 Nut Plate as per Dwg	0.00 g D2650 Bh	10/02/2	.5				<u> </u>	g manage in the second
170		QC10- Inspect visual pe	r QSJ004- ground welds	0.00 Sioloz	20						
QC Quality Control		Memo		0.00	· (3				manusch adder dem - s	All years I when the minimum beautiful	

QC5- Inspect part completeness to step on W/O

Memo

QC

Quality Control

W/O:		WORK ORDER CHANGES										
DATE	STEP	PR	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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Part No	•	DAD #.	Foult Cate		NOD V	N 50						
· art reo					NCR: Yes No DQA: Date: QA: N/C Closed: Date:							
	ne							Date:				
NCR:			WORK ORDER NON-CONFORMA									
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	n B Sign		cation	Approval	Approval			
		Section A	Chief Eng	Chief Eng	Dat		ion C	Chief Eng	QC Inspector			
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	Work Order ID 56263 Vednesday, February 17, 2010 11:05:02 AM										Page 4
tem ID: Revision ID: tem Name:	D206-642-34			Accept			111	Setuj	Start Stop		
Start Date: Required Date: Reference:	2/18/2010 3/4/2010	Start Qty: 1.00 Req'd Qty: 1.00	12 14 14 14 14 15 16 16 16 16 16 16 16	ì		Item ID: omer:					
Approvals:		in:	Date:	Tooling: SPC (Y/N):		Date:		Run	Start Stop		
Sequence ID/ Work Center II 190 HandFinish Hand Finishing		Operation Description Pressure Wash per OS100 N CAS PER DA	05 4.3 R 09-04	Set Up/ Run Hour 0.00	Dra s Nui lo(03/	mber Rev.		-	•	Reject Number	Insp. Stamp
200 Powdercoat Powder Coating		White Gloss(Ref:4.3.5.1) Memo START TIM L:U Son		0.00 0.00 0.00 = 7 0.00 = 7 1320 = 7	H 100 RATURE:	03/09	<u>(</u>	<u> </u>	X		
		QC3- Inspect Part Finish	ı	0.00	BR	10-3-	31	O	Ø.		

0.00

Memo

Quality Control

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W/O:			WORK ORDER CHANGES										
DATE	STEP	PRO	PROCEDURE CHANGE					Approval QC Inspector					
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _						
Resolution:			Disposition: Q			osed:	Date: _						
NCR:			WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC		Corrective Action Section		Verification	n Approval	Approval					
	J	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector					
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Page 5

Item ID: D206-642-341 Accept Setup Start Revision ID: Stop Replacement Skidtube Item Name: **Start Date:** Start Qty: 1.00 2/18/2010 **Cust Item ID:** Required Date: 3/4/2010 Req'd Qty: 1.00 **Customer:** Reference: Run Start Process Plan: Date: Approvals: Tooling: Date: Stop Date: **SPC (Y/N):** Date: Sequence ID/ **Operation** Set Up/ Draw Draw Plan Accept Reject Reject Insp. Work Center ID Description Number Rev. Code **Run Hours** Qty Qty Number Stamp 220 0.00 HandFinishing HandFinish Hand Finishing 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside Bl 10-4-6 230 QC3- Inspect Part Finish 0.00 Memo Quality Control 240 QC5- Inspect part completeness to step on W/O; 0.00 0.00 Memo Quality Control

	-											
W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CH		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No		PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQA	·	_ Date: _				
			Disposition: Q									
NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (NCR)						
DATE	STEP	Description of NC	Iiaii		ion B	Verifica	ation	Approval	Approval			
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	n C	Chief Eng	QC Inspector			
	-								-			
			-									

Work Order ID 56263

Page 6

Item ID:

Accept

Setup Start

Stop

Start

Stop



Revision ID:

Item Name:

Required Date: 3/4/2010

Replacement Skidtube

Start Date:

2/18/2010

Wednesday, February 17, 2010 11:05:02 AM

D206-642-341

Start Qty: 1.00

Req'd Qty: 1.00

Cust Item ID: Customer:

Number

Reference:

Approvals:

Process Plan:

QC:

Date: _____

Date: **Tooling:**

SPC (Y/N):

Set Up/

0.00

0:00

Run Hours

Draw

Date:

Date:

Draw Plan Code Rev.

Accept Qty

Reject Qty

Run

Reject Number Stamp

Insp.

250

Sequence ID/

Work Center ID

Packaging Packaging

Packaging Memo

Operation

Description

Identify and pack for shipping as per PPP D206-642-341 □ Location: □PPP Rev:

260

QC21- Final Inspection - Work Order Release

0.00



Quality Control

Memo

0.00

56261 /c//4/sc 10/04/27 H

W/O:		WORK ORDER CHANGES											
DATE	STEP	PROC	CEDURE CH	IANGE	Ву	Da	te Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Part No	:	PAR #:	_ Fault Ca	tegory:	NCR: Ye	es No	DQA:	Date: _					
Resolution:						Date:							
NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)										
DATE	STEP	Description of NC			ection B	v	erification	Approval	Approval				
		Section A	Chief Eng	Action Description Chief Eng	n Sig	n & ate	Section C	Chief Eng	QC Inspector				
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Picklist Print

Wednesday, February 17, 2010 11:05:01 AM

Work Order ID: 56263

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

ALS4-1032-130

Parent Item:

IPP Rev: H□05.10.11□ Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev: I 08-09-29 revF as per dwg DD verified by:

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Oty: 1.00

Remaining

Required Oty: 1.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID Purch Purchased

ALS7-1032-130.

Primary Item Location Nο

Last Location Route Sea ID Unit of Measure Each

Oty on Hand 1.908.000 54.0000

Otv To Pick Issued

Otv

Date Issued

Status

Page 1

Insert

Warehouse

Loc Oty

Loc Code

Location

Main Warehouse

113238.

ST

1908

110511

1908 Each

388.0000 54.0000

AN960C10L

Purchased

No

washer

NAS 1149-C03322

Warehouse Loc Qty Loc Code Location **OFFSHORE** FG 100 103585 100 Main Warehouse ST 288 112116 128 112612 160

64, BR10-41-6.

54. Bl 10-4-6.

		WO	RK ORDER CHANG	GES	****				, B			
STEP	PRO	OCEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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•	PAR #:	Fault Categ	gory:	_ NCF	: Yes	No DQ	A :	_ Date: _				
		WORK ORDER NON-CONFORMANCE (NCR)										
STEP	Description of NC		Corrective Action Section B			Verific	ation	Approval	Approval			
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Work Order ID: 56263

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:



Start Date: 2/18/2010

Required Date: 3/4/2010

Start Otv: 1.00

Required Oty: 1.00

Component Item ID/ Item Name

AN960JD10L

AN960JD416

CCR264SS3-3

Replacement Mfg/ Item ID

Purch Purchased

Purchased

Bin Primary Item Location No

Last Location Route Sea ID

Unit of Measure Each

Oty on Hand 3,457,000 2,0000

Remaining Otv Oty To Pick Issued Date Issued

Status

Washer

Warehouse	Loc Oty	Loc Code
Location		
Main Warehouse		
ST	3457	
101291	16	
101291	49	
110985	3392	

0.0000 Each

1.0000

2. blo-4-6

Purchased No

No

Each

521.0000 2.0000

- 1 1 1 1 1 1 1 1 1 1
Cherry Rivet

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
ST	29		
111548	20		-
111,827	1		
112314	2		
113539	6		
Main Warehouse			
ST311	492		
113973	492		2 BE 10/02/25

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	ROCEDURE CHANGE			у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
										ı		
Part No	•	PAR #:	Fault Cat	egory:	NCR: `	Yes N	o DQ	4 :	Date:			
Resolution:			Dispositi	on:	QA: N/	C Clos	sed:		Date: _			
NCR:			WORK ORI	DER NON-CONFORM	MANCE (N	NCR)						
DATE	STEP	Description of NC						ation	Approval	Approval		
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng	n S	ign & Date	Secti	on C	Chief Eng	QC Inspector		
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Work Order ID: 56263

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

CR3212-4-03

Replacement Mfg/ Item ID

Purch Purchased

Manufactured

Primary Item Location No

No

Last Location Route Seq ID Unit of Measure Each

Qty on Hand 242.0000 2.0000

Loc Code

Remaining Oty Qty To Pick Issued

Date Issued

Status

Cherry Rivet

Warehouse Location

Main Warehouse ST

111359 112314 242 84 158 Each

Loc Qty

10.0000 1.0000 -- BE 10-02-25

D2620



Skidtube, 206 Skidtube

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST 55559 10 10

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	OCEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Part No.		DAD #-	Fault Oat		NOD								
rait No		PAR #: esolution:											
NCR:				DER NON-CONFORM									
DATE	STEP	Description of NC			Section B			Verification		Approval			
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Work Order ID: 56263

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev: 1 08-09-29 revF as per dwg DD verified by:

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Otv: 1.00

Required Oty: 1.00

Component Item 1D/ Item Name

D2646

Replacement Mfg/ Item ID Purch Manufactured

Primary Bin Item Location No

Last Location

Route Seq ID Unit of Oty on Measure Hand Each 55 0000

Remaining Otv To Pick Issued 1.0000

Otv

Date Issued

Status

Aft Cap

Warehouse	Loc Qty	Loc Code	
Location		·	
Main Warehouse			
FP6	29		
52663	29		
Main Warehouse			
fp7	13		
52663	13		1 Bk 10-4-6.
Main Warehouse	•		•
ST	13		
46327	4		
48109	9		
	Each	90.0000 1.0000	

D2647

Cap

Manufactured No

Loc Oty

Loc Code

Location Main Warehouse ST

Warehouse

55352

90 90

_______BG 10/02/18

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W/O:			٧	VORK ORDER CHANG	ES				1
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: PAR #:			Fault Ca	_ Fault Category: NCR: Yes No DQA: Date				Date: _	
Resolution:			Disposit	_ Disposition: QA: N/C Closed:					
NCR:			WORK OR	DER NON-CONFORMA	ANCE (NC	R)		-	
DATE	STEP			· · · · · · · · · · · · · · · · · · ·	Veriti			Approval	Approval
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Work Order ID: 56263

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

Parent Item:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Otv: 1.00

Required Oty: 1.00

Component Item ID/ Item Name

D2649

Replacement Mfg/ Item ID Purch Manufactured

Bin Primary Item Location No

Last Location

Route Seq ID Unit of Oty on Measure Hand

Each

Remaining Oty To Pick Issued 245.0000 19.0000

Otv

Date Issued

Status

1 1001 1101 1110 1110 2101 2101 2110 1

Cross	Bolt	Spac	er	

Warehouse Location	Loc Oty	Loc Code	
Main Warehouse			
LG	218		<u> </u>
51529	3		·
55000	215		19 BG 10/02/
Main Warehouse			, ,
ST ,	27		
36013	5		
47112	18		
48271	4		<u></u>
	Each	450.0000 14.0000	

D2651-1

Plug

Manufactured

No



Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
fpa	295	
53349	295	
Main Warehouse		•
ST /	155	
51530	155	

14. pl 10-4-6.

W/O: WORK ORDER CHANGE					GES	GES						
DATE	STEP	PRO	OCEDURE CHA			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
				VAA.		•	14 / 18		T TOO IMG!			
Part No		PAR #:	Fault Cate	gory:	NCR:	Yes 1	No DQ	\ :	Date:			
			tion: Disposition:									
NCR:			WORK ORDI	R NON-CONFORM	MANCE	(NCR))					
DATE	STEP	Description of NC Corrective Action			Section B Ver			erification Approval		Approval		
DAIL	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	ì	Sign & Date	Section		Chief Eng	QC Inspector		
		· •								-		
				-:								
						<u> </u>						

Work Order ID: 56263

Parent Item:

D206-642-341



Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Otv: 1.00

1.0000

1.0000

Required Oty: 1.00

Component Item ID/

Item Name Item ID D2651-3

Replacement Mfg/ Purch Manufactured

Rin Primary Item Location Nο

Last Location

Route Sea ID

Loc Oty

Unit of Otv on Measure Hand 639,0000 14,0000

Loc Code

Otv Remaining Oty To Pick

Issued

Status

Issued

Date

1 188118 1819 11816 51181 51181 1181 118000 1111 1281

O-Rir	ıg		

Warehouse Location Main Warehouse

> ST 43849 46114

639 3 636 Each 4.0000

Each

14. bl 10-4-6.

D2654-5



Web

Manufactured

No

No

Loc Otv

Loc Qty

54

53

Loc Code

Location

Main Warehouse

ST

Warehouse

46638

Each

- NIO/2/23

Manufactured



Nut Plate

D2680-041

Warehouse Location Main Warehouse

ST021 33061 55366

Loc Code

54.0000

W/O:	WORK ORDER CHANGES								, <u>, , , , , , , , , , , , , , , , , , </u>	
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Ca	tegory:	NC	R: Yes	No DQ	A :	Date:	
	Resolution: Disposition:				QA: N/C Closed: Date:					
NCR:			WORK OR	DER NON-CONFO	ORMANCE	(NCR	1)			
DATE STEP		Description of NC Corrective Action			Section B Verifica			ation	Approval	Approval
	J.L.	Section A	fnitial Chief Eng	Action Descri Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
										-
									į	
	1									

Work Order ID: 56263

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

D3535-11

Item ID

Replacement Mfg/ Purch

Bin Manufactured

Primary Item Location

Last Location

Route Seq ID

Unit of Oty on Measure Hand Each 8.0000

Remaining Qty To Pick 1.0000

1.0000

Oty Issued Date Issued

Status

Wearshoe

Warehouse Location

Main Warehouse

ST

8 8

Each

10.0000

Loc Code

bl 10-4-6.

D3535-23

Wearshoe

Manufactured No

Manufactured

No

No

Loc Oty

Loc Qty

Loc Code

Location

Warehouse

ST

Main Warehouse

10 10 Each

17.0000 1.0000 IBL 10-4-6.

D3535-35



Wearshoe

Warehouse Location

Main Warehouse ST

51608

Loc Oty

Loc Code

17 17

1 pk/0-4-6.

	•										
W/O:			W	ORK ORDER CHANG	SES				f 4 2		
DATE STEP		PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date: _			
	Res	olution:	Disposition:			QA: N/C Closed: Date:					
NCR:			WORK ORD	ER NON-CONFORM	ANCE (NC	R)					
DATE	STEP	Description of NC	Corrective Action Section B Initial Action Description			0 1	cation	Approval	Approval		
		Section A	Chief Eng	Action Description Chief Eng	Sign Date		ion C	Chief Eng	QC Inspector		
									- ,		
							,				

Work Order ID: 56263

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

Manufactured

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

No

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

D3536-11

Replacement Mfg/ Item ID Purch Manufactured

Bin Primary Item Location No

Last Location Route Seq ID Unit of Measure Each

Qty on Hand 16.0000

Loc Code

Remaining Qty Qty To Pick Issued 1.0000

Date Issued

Status

Gasket

Warehouse Location Main Warehouse

ST

46715

16

Loc Qty

12 4

Each

16.0000

1.0000

D3536-23

Gasket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	3	
51609	3	
Main Warehouse		
ST /	. 13	
30754 53468	1	
53468√	12	

- ff 104-6.

	•								P • 4	
W/O:			WC	RK ORDER CHANG	ES				* * 4 1	
DATE	STEP	PRO	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:		
	Re	Resolution: Disposition:			QA: N/C Closed: Date:					
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCF	R)				
DATE STEP		Description of NC Corrective Action						Approval	Approval	
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector	
									-	
							-			

Work Order ID: 56263

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

D3536-35

Item ID

Replacement Mfg/ Purch Manufactured

Bin Primary Item Location No

Last Location Route Seq ID Unit of Qty on Measure Hand 19.0000 Each

Remaining Qty Qty To Pick Issued 1.0000

Date Issued

Status

Gasket

Warehouse Location

51628

Main Warehouse ST

Manufactured No Loc Qty Loc Code 19 19 Each

153.0000 6.0000

D3537-1

Wearpad

Wanshausa	Las Obs	I C-d-	
Warehouse	Loc Oty	Loc Code	
Location			
Main Warehouse			
FP	74		
48288	2		
55465	72		6 pt 10-11-6
Main Warehouse			•
FP17	79		
51678	1		
51679	78		

14.54

W/O:			WC	RK ORDER CHANG	`EC					• •	
			***	NA CADEA CHAIN	スピン			•		10	
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
									·		
Part No		PAR #:									
	Res	olution:	Disposition:			QA: N/C Closed: Date: _					
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (N	CR)			- 100-20		
DATE	STEP	Description of NC	Corrective Action Section B			Verific		ation Appr	Approval	Approval	
	OIL!	Section A	Initial Chief Eng	Action Description Chief Eng		n & ate	Section	on C	Chief Eng	QC Inspector	
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			·								
						:					

Picklist Print

Wednesday, February 17, 2010 11:05:01 AM

Page 10

Work Order ID: 56263

Parent Item Name:

Parent Item:

D206-642-341

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

Manufactured

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin . Primary _Item Location

No

Last Location Route Seq ID Unit of Qty on Measure Hand Each 32.0000 Remaining **Qty To Pick** 1.0000

Date Issued Issued

Qty

Status

D3537-3

Wearpad

<u>Warehouse</u>	
Location	

Location Main Warehouse

> ST 33881 35697 v

Loc Oty

32

28

Each

Loc Code

2,169.000 2.0000

1 Bl 10-4-6

MS27039-1-08

Purchased



No

Screw

Warehouse	Loc Qty	Loc Code
Location		

Main Warehouse

ST

110467 110552 110835 2169 3 166

2000

2 fd 10-4-6.

	-										
W/O:			WC	RK ORDER CHANG	GES					. 3	
DATE	STEP	PRO	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							11111				
Part No		PAR #:									
		esolution:	Disposition:								
NCR:			WORK ORDE	R NON-CONFORM	ANCE (ICR)					
DATE	STEP	Description of NC	Corrective Action Section B			Verification			Approval Chief Eng	Approval QC inspector	
	Section A		Initial Action Descri Chief Eng Chief Eng				Section C				
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Picklist-Print

Wednesday, February 17, 2010 11:05:01 AM

Work Order ID: 56263

Parent Item:

D206-642-341

Parent Item Name:

Replacement Skidtube

Comments:

IPP Rev: H□05.10.11□Added D3429-1 per CHG004□KJ/CP/JLM

IPP Rev:I 08-09-29 revF as per dwg DD verified by:

No

Start Date: 2/18/2010

Required Date: 3/4/2010

Start Qty: 1.00

Required Qty: 1.00

Date

Issued

Component Item ID/ Item Name

Item ID

Replacement Mfg/ Purch Purchased

Primary Item Location No

Last Location Route Seq ID Unit of Qty on Measure Hand Each

Remaining **Qty To Pick** 2,169.000 54.0000

Qty Issued

Status

Page 11

MS27039-1-08

E IRRIPOLI CININ CON CENTI INCIDENTANTA DE LOS MANOS M

#	
Camana	

Screw

3	Var	eho	use

Loc Qty

Loc Code

Location Main Warehouse

ST

110467 110552 110835 2169 3 166

2000

Each

49.0000 1.0000

54.bl 10-4-6.

MS27039-4-06

Purchased

Screw

Warehouse Location

ST 109061

Main Warehouse

Loc Qty

Loc Code

49 49

The 10-4.6.

	-								• 3 ·
W/O:			W	ORK ORDER CHANG	SES				,
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:							
	Res	solution:	Dispositi	on:	QA: N/C C	losed:		Date: _	
NCR:			WORK ORI	DER NON-CONFORM	ANCE (NC	7)			
DATE	STEP	Description of NC	Corrective Action Section				cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign o		on C	Chief Eng	QC Inspector
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									7.11
				·			,		

QTY QTY QTY QTY **PART NUMBER** DESCRIPTION D2650-1 SKIDTUBE ASSEMBLY Х D2650-3 SKIDTUBE ASSEMBLY X D2650-5 SKIDTUBE ASSEMBLY D2650-7 SKIDTUBE ASSEMBLY Х D2600-1-160 **EXTRUSION** D2654-1 WEB D2654-3 WEB D2654-5 WEB 1 D2654-7 WEB D2646 AFT CAP D2647 CAP 1 17 18 19 23 D2649 CROSS BOLT SPACER 16 18 22 14 D2651-1 PLUG 16 18 14 22 D2651-3 O-RING 1 D2680-041 NUT PLATE 2 2 D3286-1 DOUBLER D3286-3 2 2 STUD 42 54 60 ALS7-1032-130 INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) AN960JD10L WASHER 2 2 2 2 2 2 2 2 CCR264SS3-3 RIVET 2 2 2 2 CR3212-4-03 RIVET SCREW 2 2 2 2 MS27039-1-08 1 1 MS27039-4-06 SCREW AN960JD416 WASHER 1 52 52 RIVET CR3212-4-04

С

В

NOTES:

D

1) MATERIAL: N/A

2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 -BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART OSI 005 4.4

- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

8

9) DAMAGE TOLERANCE ON FWD BEND:

THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DECICN	DADT ACROODS	F 110	A 1110
REV.	DESCRIPTION	BY	DATE
Α	NEW ISSUE	DS	97.03.25
В	AS MANUFACTURED CHANGES	DS	97.06.26
С	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
D	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	СР	04.05.17
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6. SHT 1 IN PL PART D2649 CTY UPDATED. SHT 6. SECT CC GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NOR 239).	AJS	08.08.08

DESIGN	DS	■ DART AEROSPACE US	SA. INC I		
DRAWN	AJS	PORT HADLOCK, WA	, · · ·		
CHECKED		DRAWING NO.	REV. F		
MFG. APPR.	E	D2650	SHEET 1 OF 6		
APPROVED	140	TITLE	SCALE		
DE APPR.	-	206/407 SKIDTUBE ASSEMBLIES	NTS		
DATE OR O	8 08	COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS			

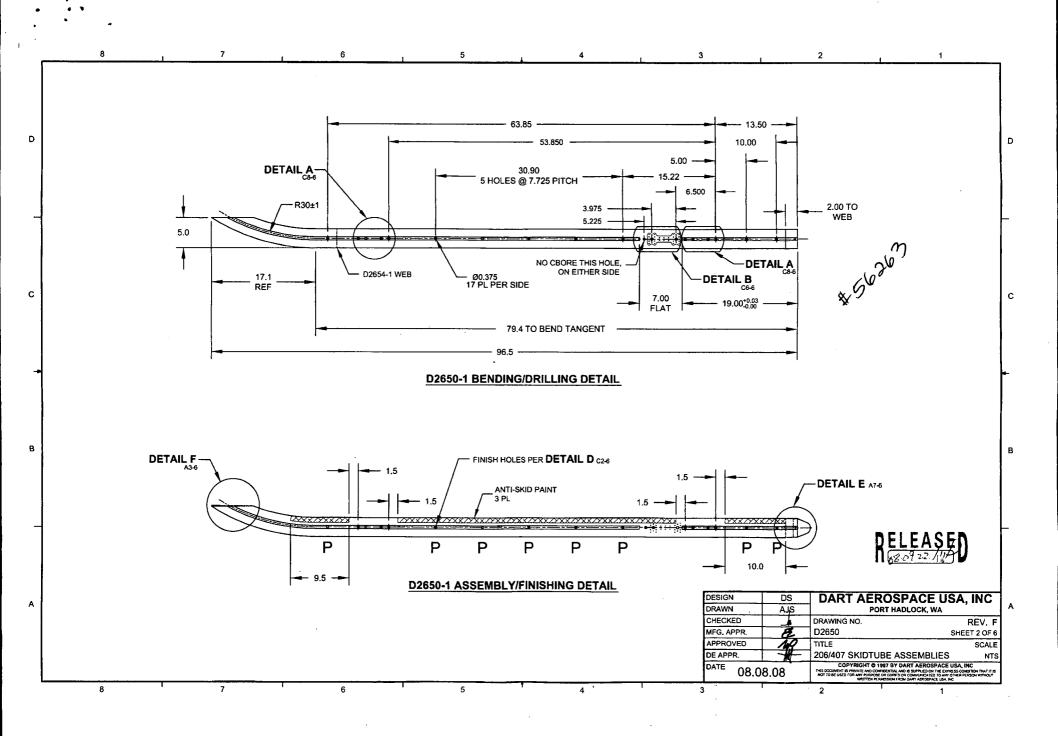
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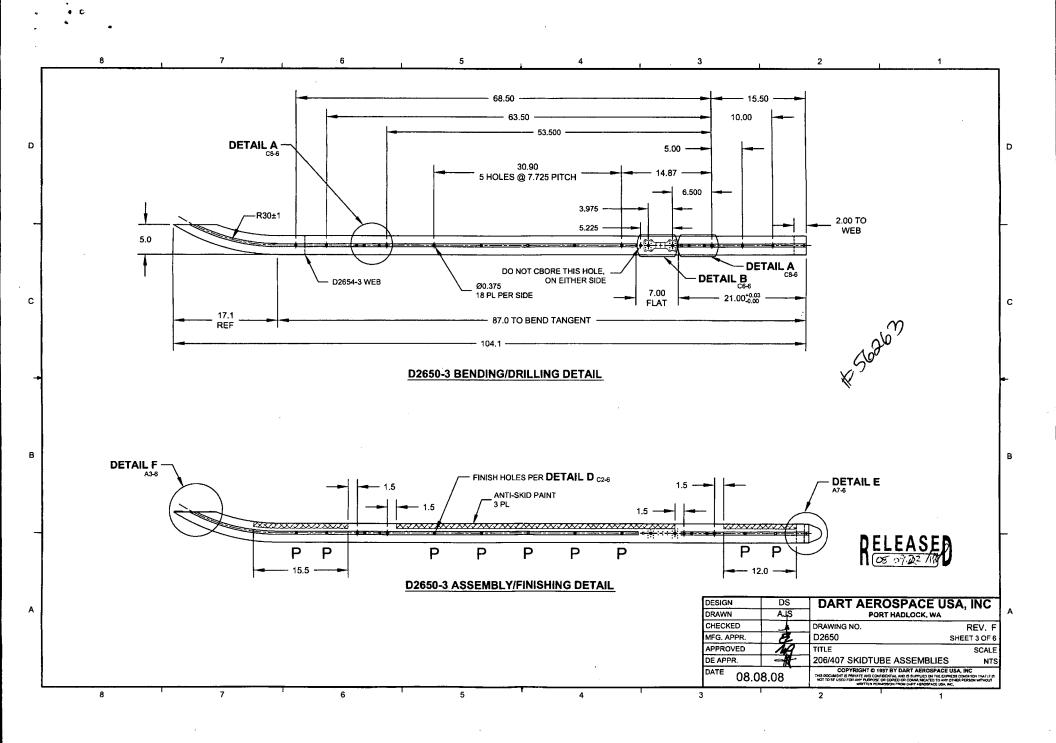
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DATE	E STEP Description of NC Corrective Action			ection B		cation	Approval	Approval	
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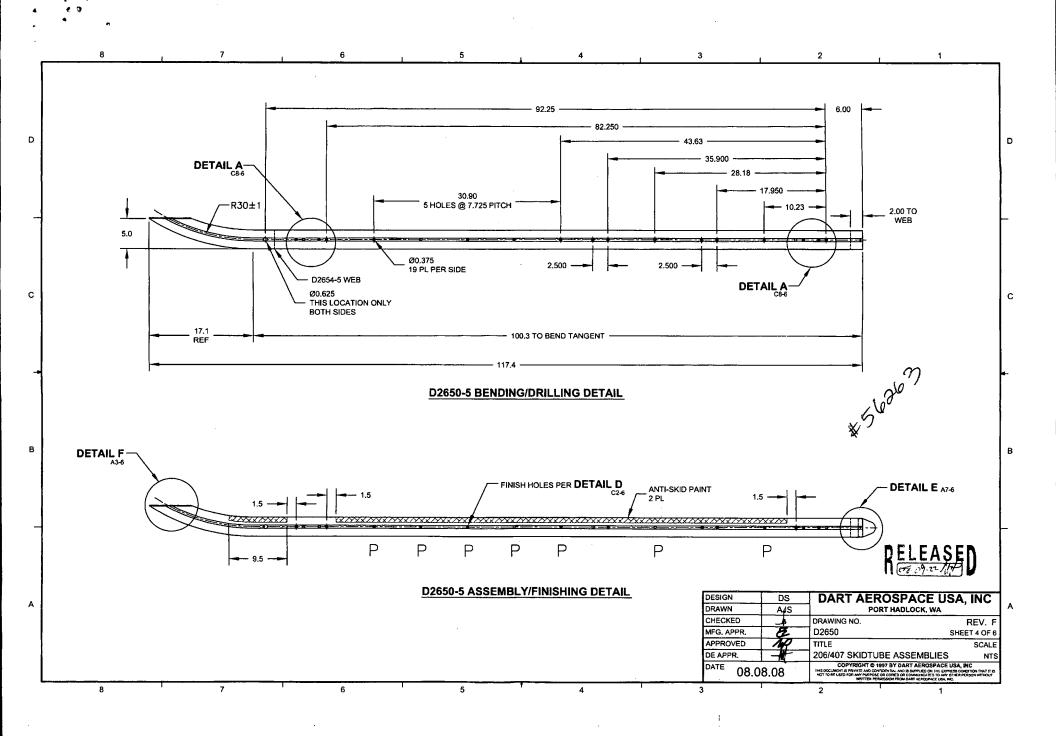
Dart Aerospace Ltd

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W/O:			W	ORK ORDER CHANGI	ES				• •		
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				Fault Category: NCR: Yes No I				o DQA: Date:			
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DATE STEP		Description of NC		Corrective Action Section B			ation	Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector		
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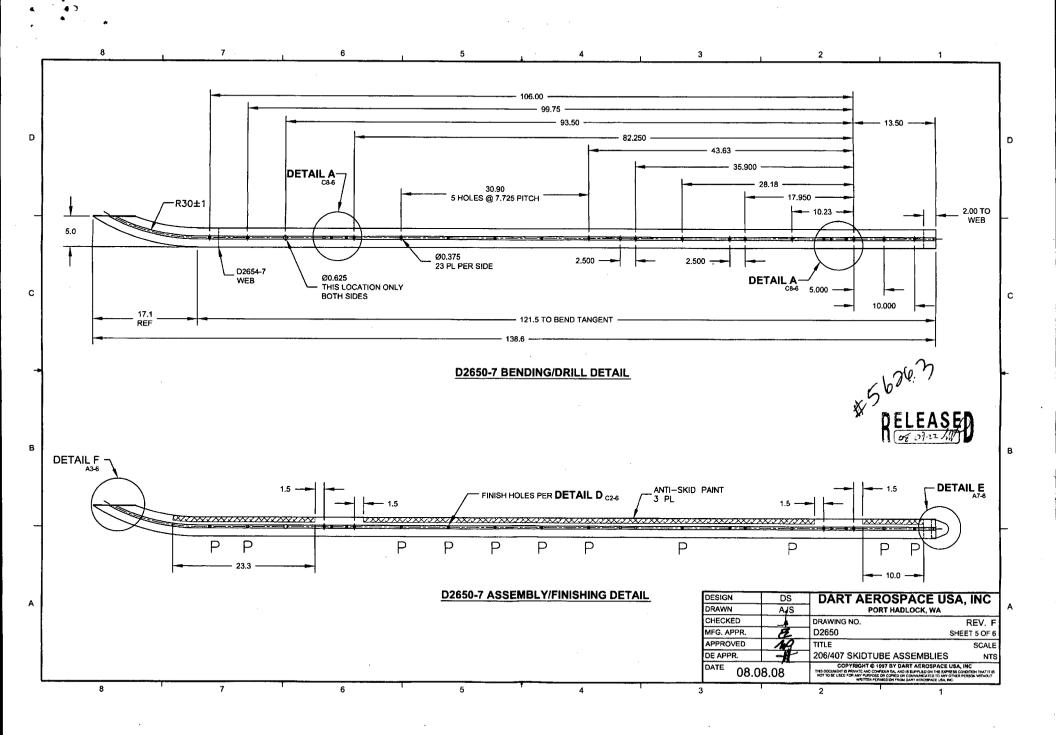
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W/O:		WORK ORDER CHANGES										
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		olution:	Disposition	on:	QA: N/C Closed:							
NCR:			WORK ORE	ER NON-CONFORI	MANCE (NCR)			****	4.00		
DATE	STEP	Description of NC Section A	Corrective Action Solution Initial Action Description		Section B on Sign &		Verification		Approval	Approval		
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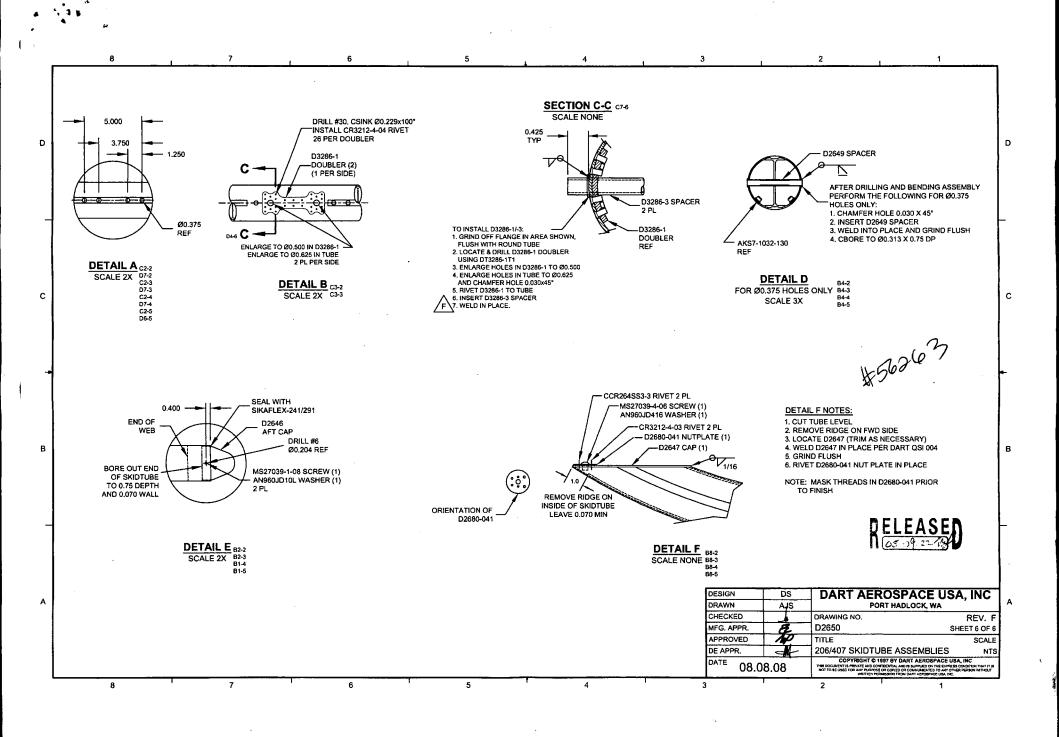
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W/O:		WORK ORDER CHANGES											
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)							
DATE STEP		Description of NC	Corrective Action Section		Verificati	on Approval	Approval						
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W/O:			V	VORK ORDER CHA	ANGES					* ,
DATE	STEP	PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	R #: Fault Category: NO			CR: Yes No DQA:			Date:	
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NCR:		W	ORK OR	DER NON-CONFO	RMANCE	(NCR))			
DATE	CTED	Description of NC Section A	Corrective Action Section B			٠,	Verific	ation	Approval	Approval
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NO. 323

AWS D17.1.2001 QUALIFICATION TEST RECORD

Name: Darden Fllott	
Job number: 3 \$ 55777	-
Part number: 0206 - 642 - 441	_
Description: 206 skid tube	-
Welding Process: Tig[Mig[]	-
Base materiel: Aluminian	
Current: AC[DC[]	_

TEST REQUIREMENTS AND RESULTS

	fail[]
pass[´j	fail[]
pass[]	fail[]
	fail[]
	£ _3
	fail[]
pass[]	fail[]
Doto of To	-4 C
_nate of Te	st Coupon 10.02.16
_ Date of Te	st Coupon <u>10-02-16</u>
	pass[] pass[] pass[] pass[] pass[] pass[] pass[]

The above named individual is qualified in accordance with AWS D17.1.2001 to weld